

# Work Order ID 53694

November 12, 2009 4:07:24 PM



Page 1

Item ID: D205-634-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube

Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109111

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date: 02-11-12

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D205-634

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Original B47906 @ CHG007. Kit and part is complete & in good condition

1 02-11-12

110

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

New labels are required with the new batch # @ CHG007. Clean & repackage & return to stock.

09-11-13  
11/11/16

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17  
ME 09-11-16

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D205-634-011	CHG	CHG007
DESC	Skidtube	STC	SH96-88
LOT	B47906	STC	SR00563NY
MODEL	Bell 205/210/212/214/412/UH-1H		
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

Date: Tuesday, 12/05/2009 2:12:10 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY  
 Job Number : 47906  
 Estimate Number : 10022  
 P.O. Number : Part Number : D205634011  
 This Issue : 12/05/2009 S.O. No. : Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 1 / 1 Type : SKIDTUBES Drawing Revision : F  
 Previous Run : 47243 Material :  
 Written By : Due Date : 29/05/2009

Checked & Approved By : JLD 09.05.12  
 Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ  
 Est Rev:Q 08-08-12 now @ chg 006 (DSI 9417) DD verified by:  
 Est Rev R 09.01.28 now chg 007 DSI9417 revB EC  
 verified by:  
 Est Rev:S 09-03-16 rev.f as per IIN DD verified by:JLM

REFERENCE ONLY

1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



HJ for JLD 09/06/08



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-011

CHG007

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 47906A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

1 x D205-634-041 Batch 47906 A SP

4.0 K10003 Saddle, D205-634-011



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	47246

9/6/11

50

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Date: Wednesday, 22/04/2009 8:11:50 AM  
User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT  
Job Number : 47216  
Estimate Number : 10532  
P.O. Number :  
This Issue : 22/04/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : 15/04/2009 Type : MACHINED PARTS  
Previous Run : 47027  
Written By :  
Checked & Approved By :  
Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011  
KJ/RF

Part Number : K10003  
Drawing Number : 634, 635 IIN  
Project Number : N/A  
Drawing Revision : F  
Material :  
Due Date : 27/04/2009 Qty: 6 Um: Each

Est : J 06-07-25 As per DSI 9344 JLM  
Est : K 06.11.17 Per K10003 Rev C KJ  
Est : L 07.01.12 Document Record for copying bluefile rmv KJ  
Est Rev: M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:  
Est N 09.01.27 DSI 9418 rev B EC verified by: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for CL 09/06/08



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 007

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	B46431

4.0 D2571 Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	47247

Date: Wednesday, 22/04/2009 8:11:51 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47216

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

1

D2572

Saddle

46953

REFERENCE ONLY

SS 09/05/22 (x6)

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

1

D2573

Saddle

B 39808 x1

46954 x5 -

SS 09/05/22 (x6)

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

1

D2574

Saddle

47567 x2 -

47250 x4 -

SS 09/05/22 (x6)

8.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405041

Lug Assembly

47200

SS 09/05/22 (x6)

9.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405043

Lug Assembly

47308

SS 09/05/22 (x6)

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

4

D2747

Socket Head Set Screw

43855

SS 09/05/22 (x6)

Date: Wednesday, 22/04/2009 8:11:51 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47216

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

42364

SS 09/05/22 (x6)

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

43857

SS 09/05/22 (x6)

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

Batch:

44644

SS 09/05/22 (x6)

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

M 110399

SS 09/05/22 (x6)

15.0

AN4C47A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

batch:

M 111425

SS 09/05/22 (x6)

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M 110328

SS 09/05/22 (x6)

Date: Wednesday, 22/04/2009 8:11:51 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47216

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M111193

REFERENCE ONLY

18.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M111279

19.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M111193

20.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Nut

Batch: M110450

21.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

batch: 47309

22.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: B46752

Date: Wednesday, 22/04/2009 8:11:51 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47216

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS210434

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)

Nut

batch:

M111295

24.0

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

batch:

B44350

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Rev J

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-08

REFERENCE ONLY

SS 09/05/22 (x6)

SS 09/05/22 (x6)

09/06/08 (6)

SS 09/06/08 (x6)

09/06/08